

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015368**Date Inspected:** 06-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 9BE/9CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBE9B-008, Bottom Plate Splice. The welder is identified as #054467 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1, UT repair for WR13918.

This QA Inspector observed Base Metal Repair using the Shielded Metal Arc Welding (SMAW) process at locations of removed fit up plates along the exterior of the Edge Plate transverse CJP splice. The welder is identified as #048659 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 for WR13193.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBE9-006, Edge Plate Splice. The welder is identified as

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#054467 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1, UT repair for WR13937.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP698-001-019, Deck Plate I-rib Splice. The welder is identified as #053753 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-485-SMAW-3G (3F)-FCM-repair-1, UT repair for WR13934.

Segment 9AW/9BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA055-005 and CA059-001, Deck Plate to Edge Plate. The welder is identified as #045196 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-P-2211-TC-U4b-FCM-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Wang Li Yang. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 9CE

This QA Inspector observed beveling of the Side Plate with the use of a mechanical guided torch, bike path side.

Segment 9AE/9BE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Longitudinal Diaphragm Hold back fillet welds, cross beam side.

Segment 9AW/9BW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Bottom Plate transverse CJP splice, D scan was performed.

Segment 9AW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Side Plate WT stiffener Hold back fillet welds, Counter weight side at the 8CW/9AW field splice location.

Segment 9DE

This QA Inspector observed fit up of the Bottom Panel to FL3 Flange at panel points 80-82.

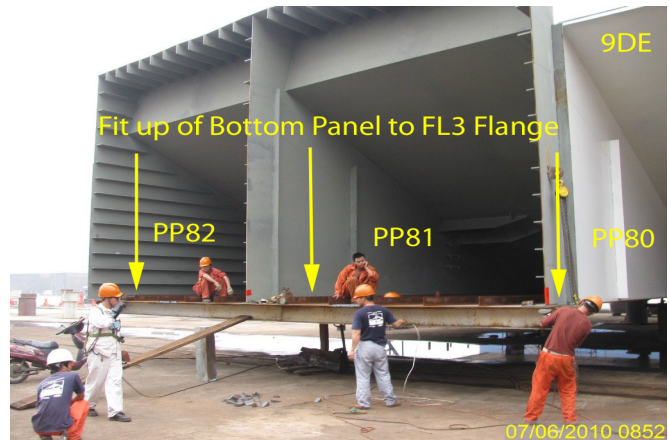
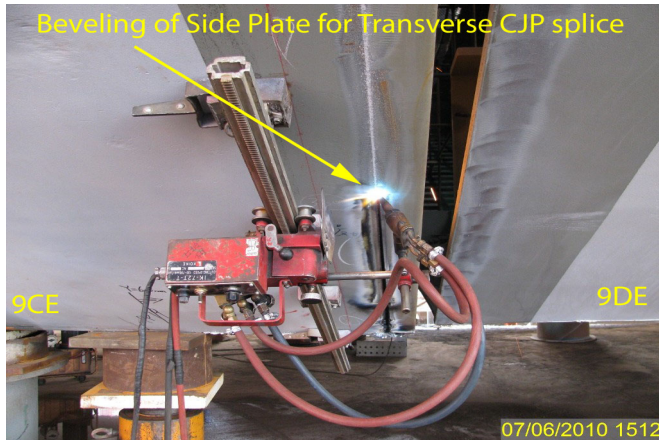
Lift 8 West

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This QA Inspector observed grit blasting in progress on the exterior of the segments.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Dan

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer